

# Work Order ID 60722

Wednesday, July 21, 2010 10:20:41 AM



Page 1

Item ID:	D3916-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib Assembly				Stop	
Start Date:	7/21/2010	Start Qty:	6.00			
Required Date:	7/28/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:	<u>K</u>	Date:	<u>10-7-21</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								

100		0.00							
Large Fab									
Large Fab	<p><b>Memo</b></p> <p>1- Cut tube 50"</p> <p>2- Bend tube with manuel pipe bender as per DT9567</p> <p>*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***</p> <p>3- Trim access tube material to finish size as per dwg D3916</p> <p>4- Drill and chamfer holes as per dwg D3916-1 using DT9605</p> <p>5- weld bushing as per dwg D3916</p> <p>6- grind welds flush</p>	0.00							

6 PD 10.08.20

SAD 10-03-09

110		0.00							
QC									
Quality Control	<p><b>Memo</b></p> <p>QC5- Inspect part completeness to step on W/O</p>	0.00							

8/10/08/20

76

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


**NOTE:** Date & initial all entries



# Work Order ID 60722






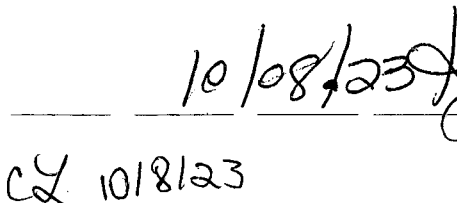
Wednesday, July 21, 2010 10:20:42 AM



Page 2

Item ID: D3916-041 Accept  Setup Start   
Revision ID: Stop   
Item Name: Rib Assembly  
Start Date: 7/21/2010 Start Qty: 6.00  Cust Item ID:  
Required Date: 7/28/2010 Req'd Qty: 6.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00							
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u>  Memo	0.00 0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 21, 2010 10:20:46 AM

Page 1

Work Order ID: 60722

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Start Date: 7/21/2010



Required Date: 7/28/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1  Bushing		Manufactured	No			100	Each	49.0000	7	42			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		49							
				54072		9							
				60241		40							
M304TS0.750W.049  304 SQ Tube .75x.75x.049W		Purchased	No			100	f	176.1036	4.166	26.31158			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT		40.83646794							
				113763		0							
				114323		20.0582189							
				114677		14.34201							
				114835		6.436239							
				MAT017		3.68448E-05							
				114298		3.6845E-05							
				WA		135.2671							
				114992		135.2671							

B60719-22 PD 10.05.20

B61348-22

SAD 10-08-09

26.3118

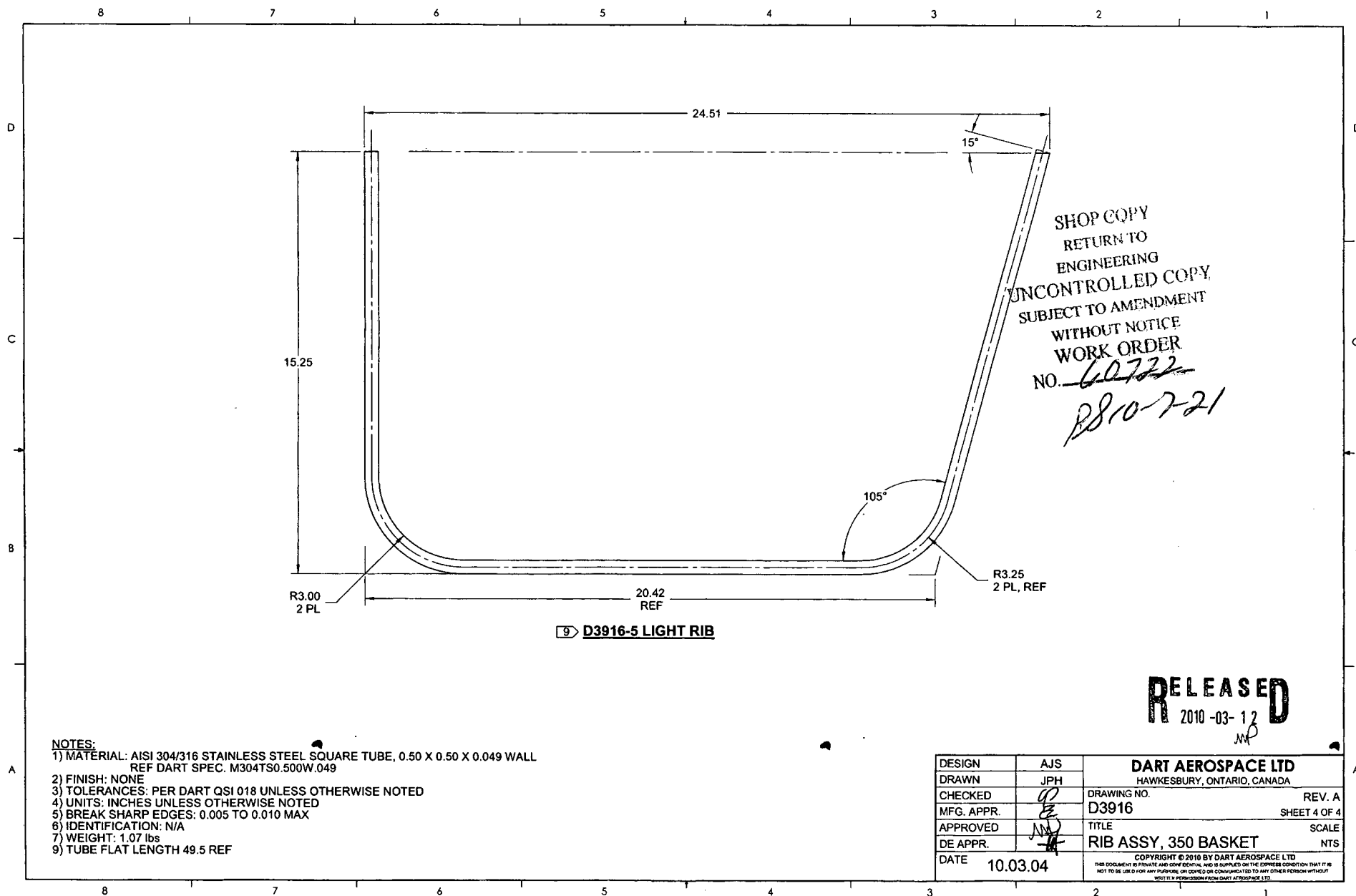
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**NOTE:** Date & initial all entries



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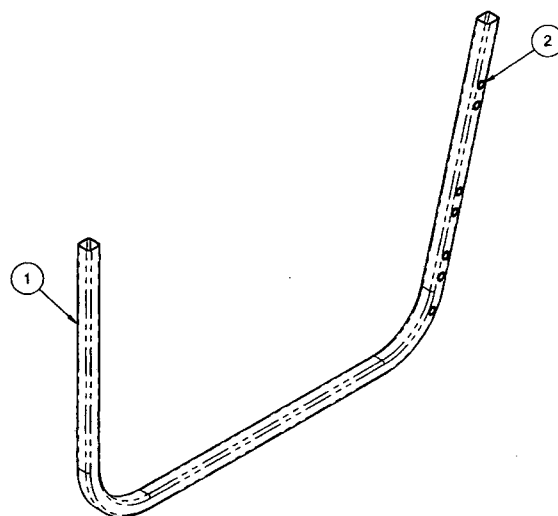
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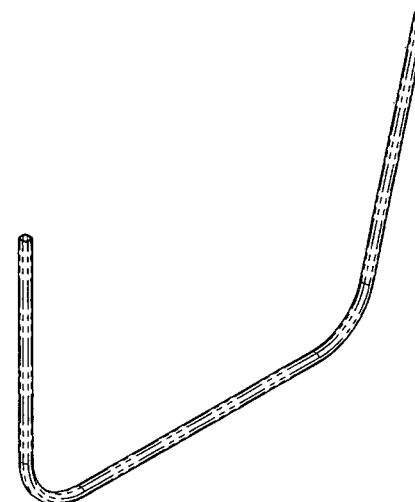
**NOTE:** Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



**D3916-041 RIB ASSY**



**D3916-5 LIGHT RIB**

*w/o 60722*

**RELEASED**  
2010-03-12  
*MP*

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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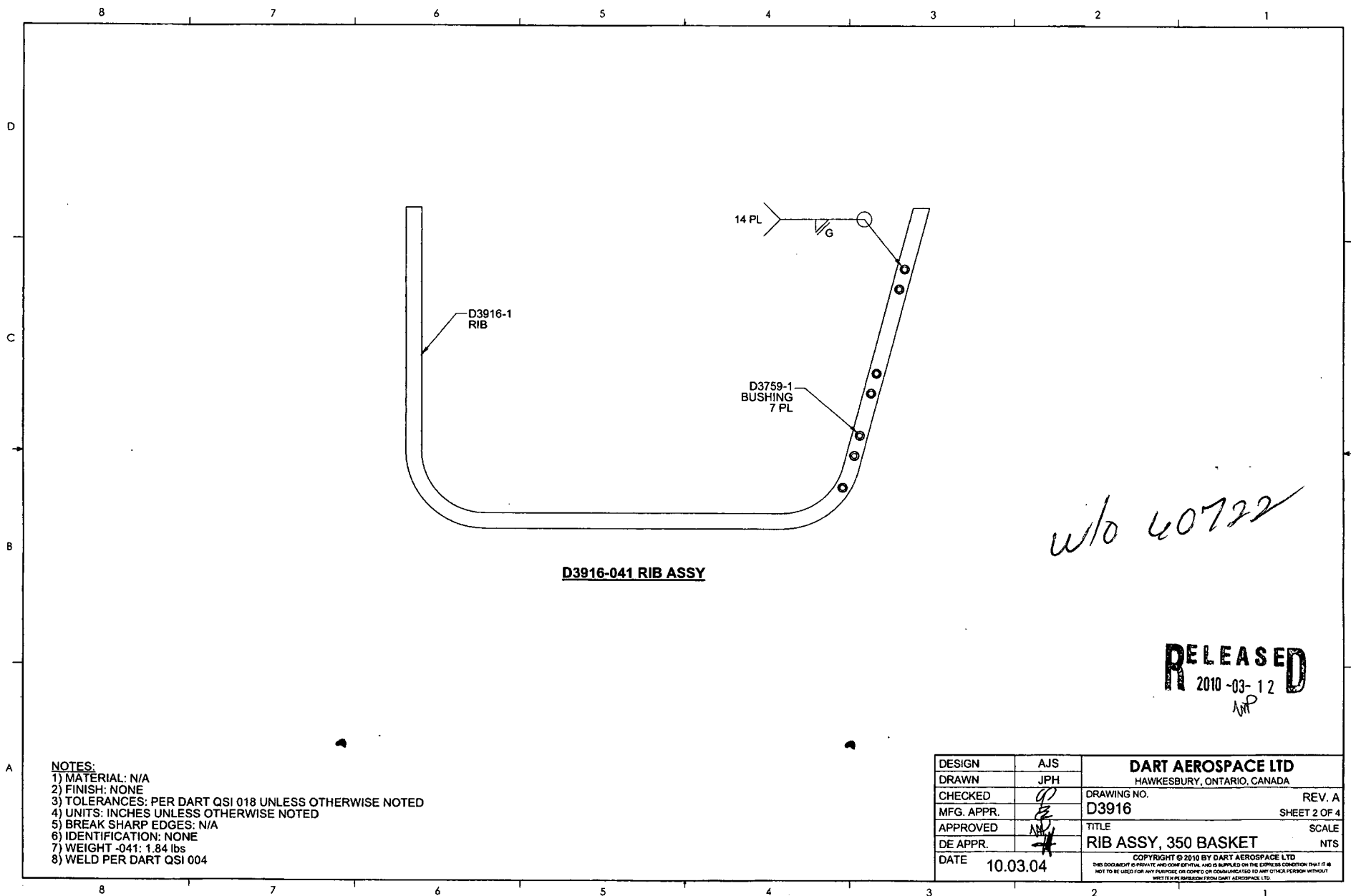
**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

W/O:		WORK ORDER CHANGES					
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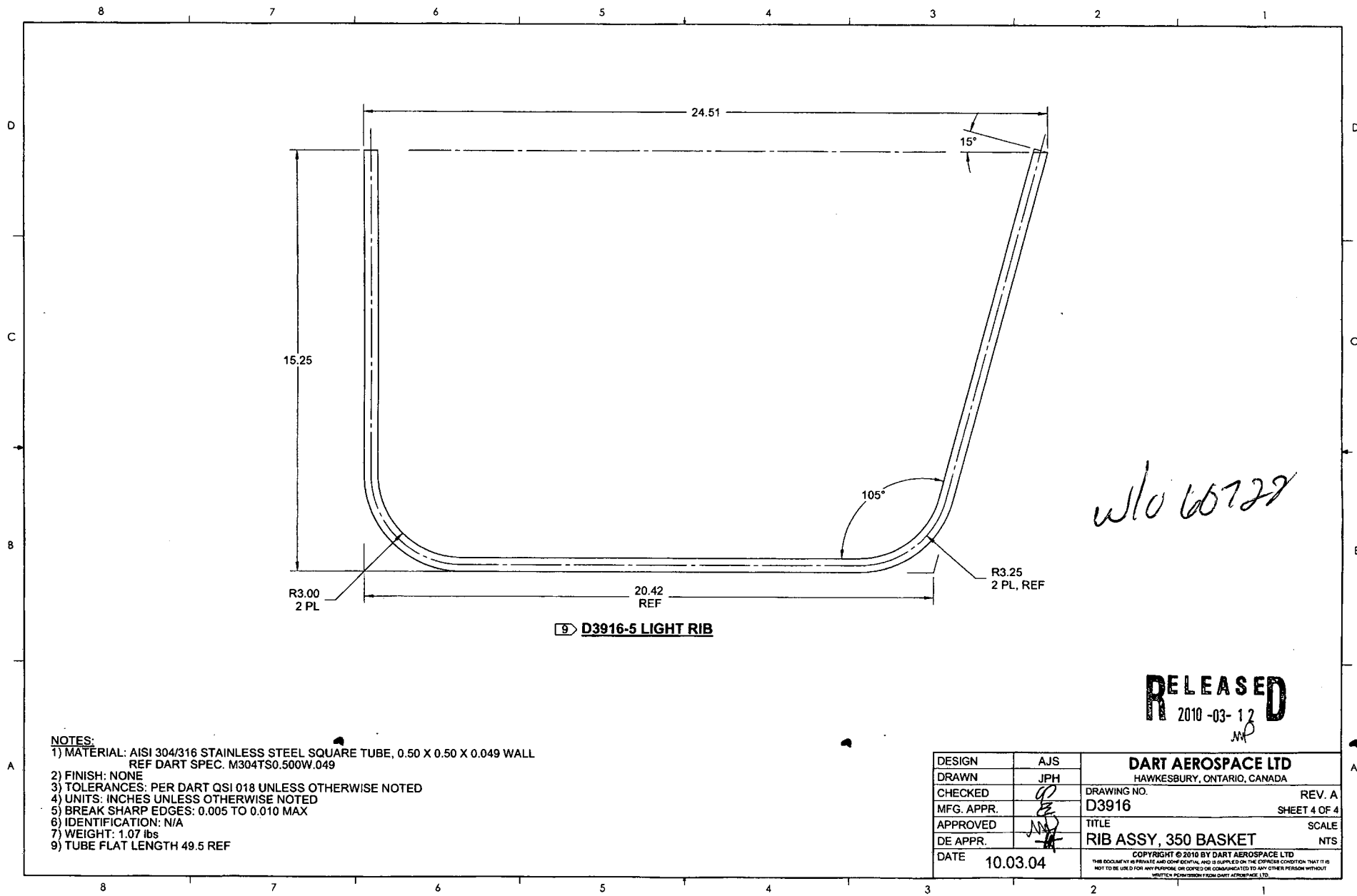
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**NOTE:** Date & initial all entries



*w/o 65722*

**RELEASED**  
2010-03-12

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.07 lbs
  - 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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